

Date: Wednesday, 10/31/2007 3:26:05 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	TUBE	
Job Number	35472				
Estimate Number	11168				
P.O. Number	:		Part Number	D22823	
This Issue	10/31/2007	S.O. No.	Drawing Number	D2282 REV E	
Prsht Rev.	NC		Project Number	N/A	
First Issue	/ /	Type	Drawing Revision	E	
Previous Run	33829		Material	:	
Written By	:		Due Date	11/30/2007	Qty: 250
Checked & Approved By	djl 07/11/01		Um:	100	
Comment	Est Rev A		Removed from 9 Digit	05-12-02	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0675W091	304 RD Tube .675 x .091W	
		Comment: Qty.: 0.2078 f(s)/Unit Total : 20.7795 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) S1.5' Batch 1105223	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA188	
		2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	
		BASIC 64	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 35472

Part Number: D22823

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



07.11.15 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33472
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: DSP
Date: 07/11/12

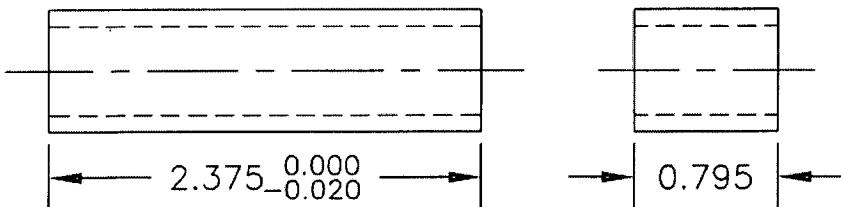
Audited by:	<i>[Signature]</i>
Date:	02.04.2022

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Tolerance changed	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	✓ ✓



DESIGN BW	DRAWN BY <i>PZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>IP</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

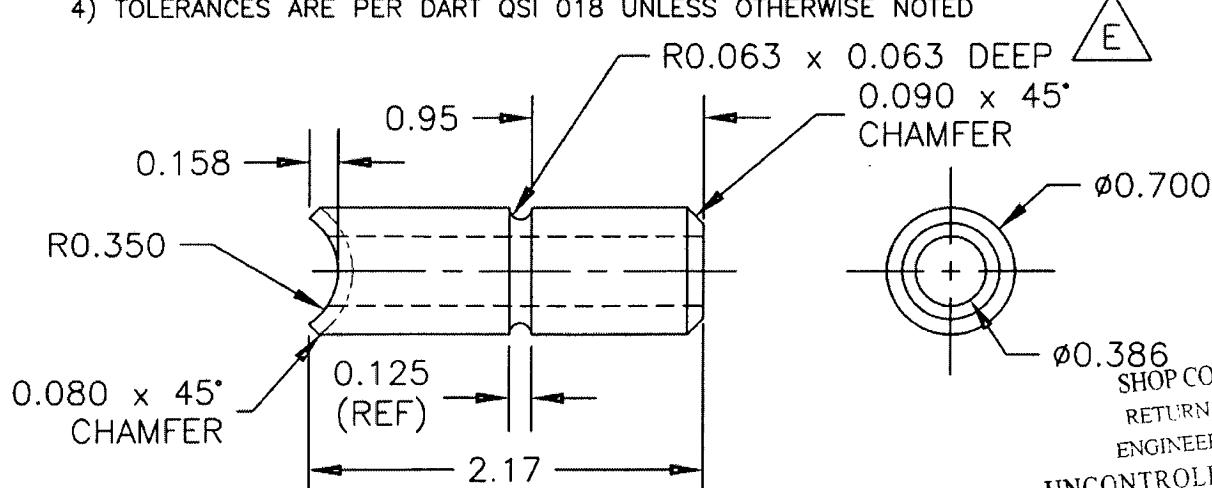


D2282-3

D D2282-7

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304R0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D D2282-5

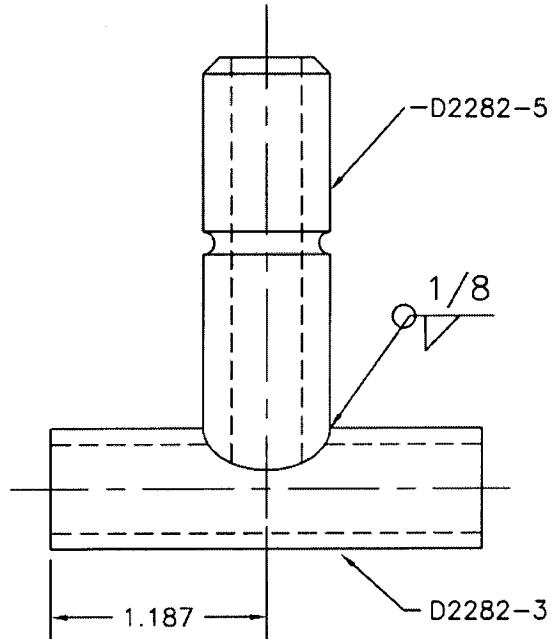
D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

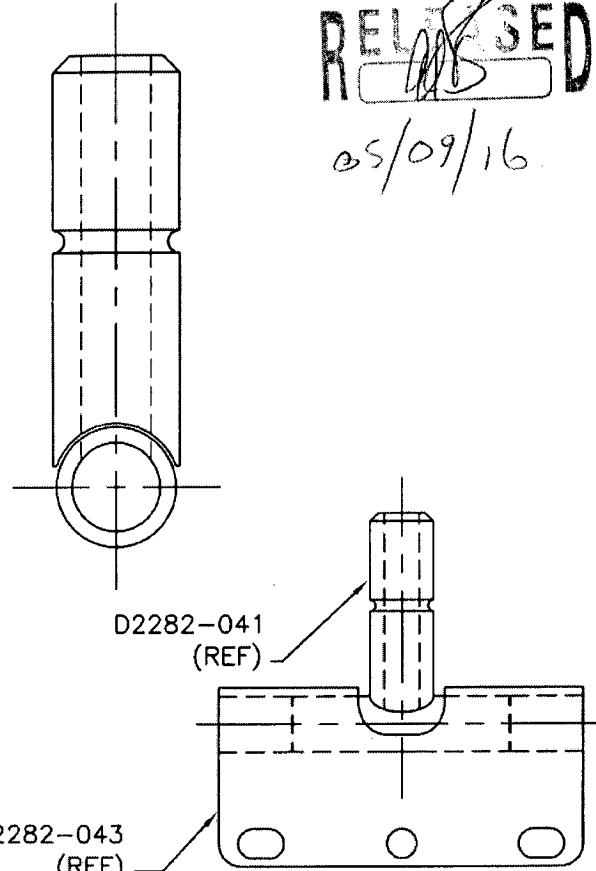
E

DART

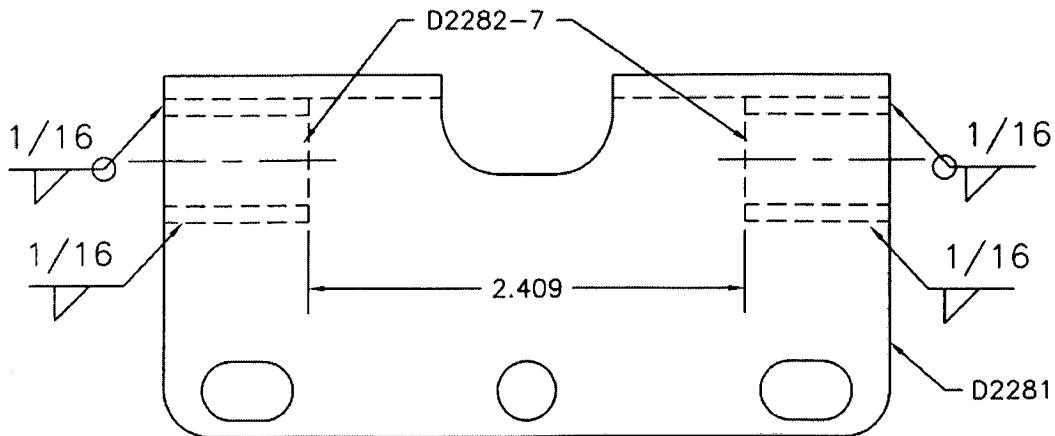
DESIGN BW	DRAWN BY <i>RE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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WITHOUT NOTICE
WORK ORDER
NO. 35472